

Work Order ID 64553

Wednesday, December 08, 2010 10:23:42 A



Page 1

Item ID: D3315-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 12/8/2010 Start Qty: 5.00



Cust Item ID:

Required Date: 12/22/2010 Req'd Qty: 5.00

Customer:

Reference:

Approvals:

Process Plan: PL

Date: 10-12-8

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3315	Rev B								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3315 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary

1010 - 060

B10-12-23



110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B10-12-23

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8 10/12/23



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 64553

Wednesday, December 08, 2010 10:23:42 A



Page 2

Item ID:	D3315-3	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Wearplate					
Start Date:	12/8/2010	Start Qty: 5.00		Cust Item ID:		
Required Date:	12/22/2010	Req'd Qty: 5.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	NC BRAKE	0.00							
Brake NC	Memo	0.00				5			
Brake NC	Form using DT8179 Die and DT8157 as per Dwg D3315 Rev: B		Sp	11/01/03					
140 	QC6- Inspect dimensions to drawing	0.00							
QC	Memo	0.00				45			
Quality Control						3			
150 	Large Fab	0.00							
Large Fab	Memo	0.00							
Large Fab	Weld hard surface using D3315-3T3 as per QSI 004 and Dwg D3315 Rev: B								
	Part Number Description Batch A/R								
	N/A 7560 Hardcoat Rod 11/15/02								

W/O:		WORK ORDER CHANGES					
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Work Order ID 64553

Wednesday, December 08, 2010 10:23:42 A

Page 4

Item ID: D3315-3

Accept

Revision ID:

Item Name: Wearplate

Start Date: 12/8/2010 Start Qty: 5.00

Required Date: 12/22/2010 Req'd Qty: 5.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

5 6 11/01/14

200

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify on inside surface using a permanent fine point marker with the following: ☐TCCA-PDA, Dart Aerospace Ltd. ☐P/N: D3315-3, B/N: BXXXXX ☐For Product Eligibility see PDA04-17 ☐and Stock ☐Location: 496

11/01/14 SP

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/01/14

11-01-14

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NOTE: Date & initial all entries

Picklist Print

Wednesday, December 08, 2010 10:23:46 AM

Page 1

Work Order ID: 64553



Parent Item: D3315-3



Parent Item Name: Wearplate



Start Date: 12/8/2010

Required Date: 12/22/2010

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP: A 05.05.12 New issue KJ/JLM
IPP Rev:B As per Rev B 06-03-24 JLM
IPP Rev:C Now on Waterjet 07-07-11 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S16GA  1010/1025 sheet 16GA		Purchased	No			100	sf	84.5250	2.296	12.08421			
													

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	44333
Description: Wearplate		Part Number:	D3315-3
Inspection Dwg: D3315 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
62.75	+/-0.030	62.75	✓		IB02	
58.094	+/-0.010	58.094	✓		T	
51.368	+/-0.010	51.368	✓		T	
44.531	+/-0.010	44.531	✓		T	
37.719	+/-0.010	37.719	✓		T	
30.375	+/-0.010	30.375	✓		T	
24.188	+/-0.010	24.188	✓		T	
18.875	+/-0.010	18.875	✓		T	
17.375	+/-0.010	17.375	✓		T	
10.594	+/-0.010	10.594	✓		T	
5.375	+/-0.010	5.375	✓		V IB02	
0.875	+/-0.010	0.877	✓		V	
1.62	+/-0.030	1.62	✓		V	
5.214	+/-0.010	5.214	✓		V	
4.402	+/-0.010	4.404	✓		V	
3.500	+/-0.010	3.555	✓		V	
Ø0.300	+0.006/-0.001	0.301	✓		V	
Ø0.266 x 0.450	+/-0.010	0.265 x 0.450	✓		V	

Measured by:	RB	Audited by:	S	Prototype Approval:	N/A
Date:	10-12-23	Date:	10/12/23	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.22	New Issue	KJ/EC/DD	AS

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

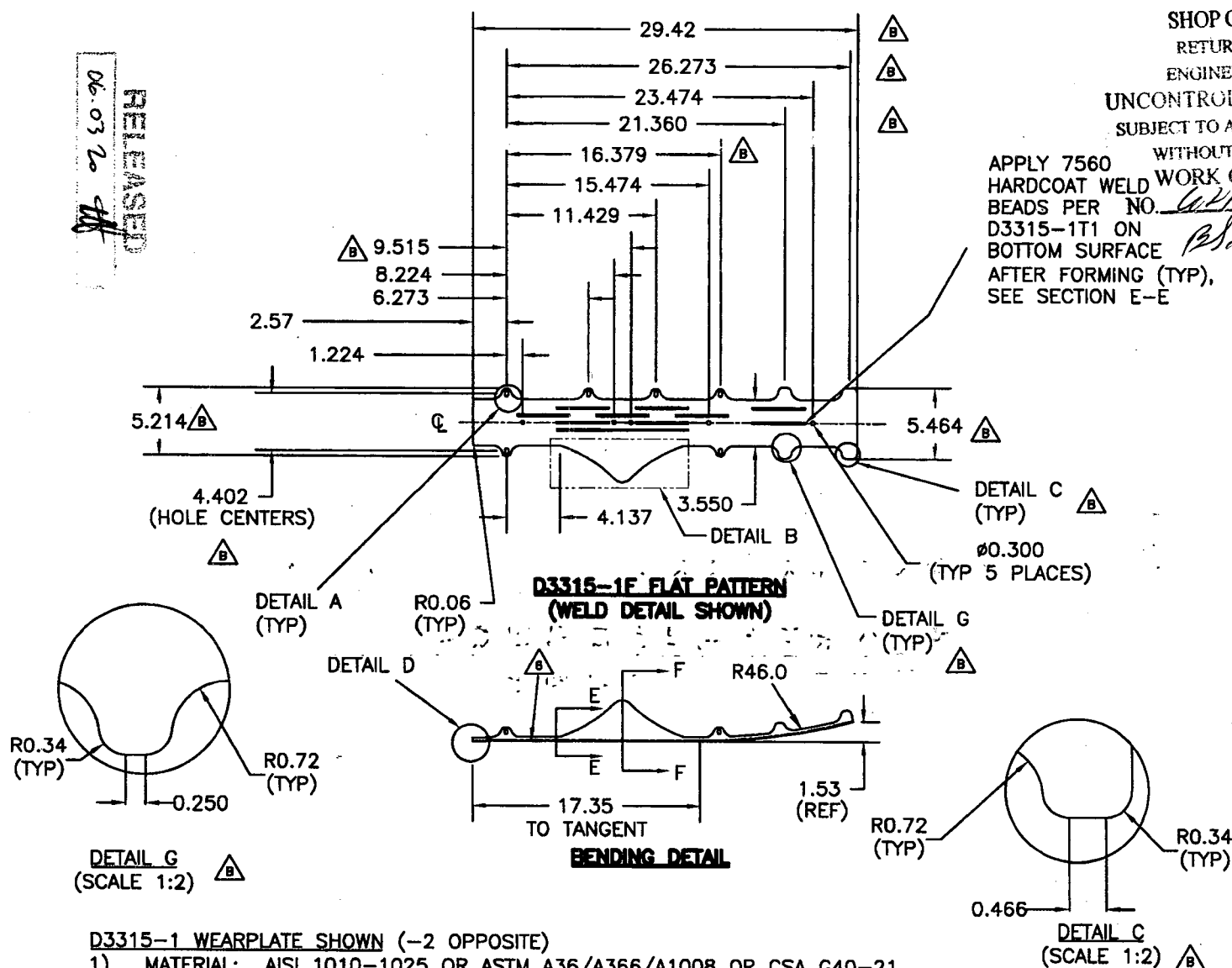
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NOTE: Date & initial all entries

DART

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

APPLY 7560 WITHOUT NOTICE
HARDCOAT WELD WORK ORDER
BEADS PER NO. 621353
D3315-1T1 ON Bottom
BOTTOM SURFACE
AFTER FORMING (TYP),
SEE SECTION E-E



D3315-1 WEARPLATE SHOWN (-2 OPPOSITE)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
*TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

DESIGN	DRAWN BY	DART AEROSPACE LTD
84	84	HAMKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
		D3315
DATE	TITLE	SCALE
06.01.31	WEARPLATE	1:12
A	NEW ISSUE	REV. B
04.09.10		
B	UPDATE DIMENSIONS	SHEET 1 OF 4
06.01.31		

RELEASED

06.03.20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

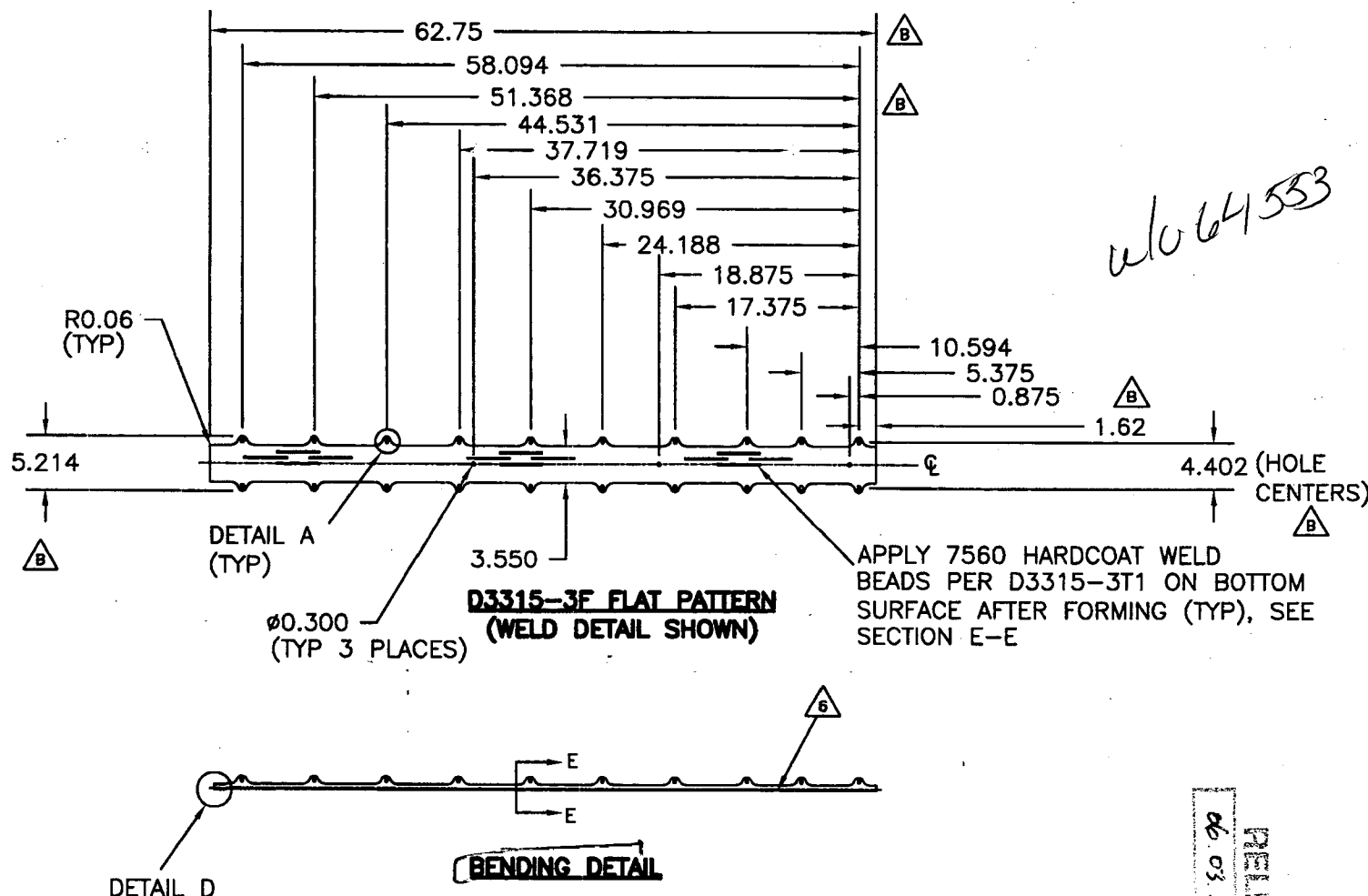
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	D3315
DATE	06.01.31	TITLE	WEARPLATE	REV. B	SHEET 2 OF 4
		SCALE	1:16		



D3315-3 WEARPLATE SHOWN (-4 OPPOSITE)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

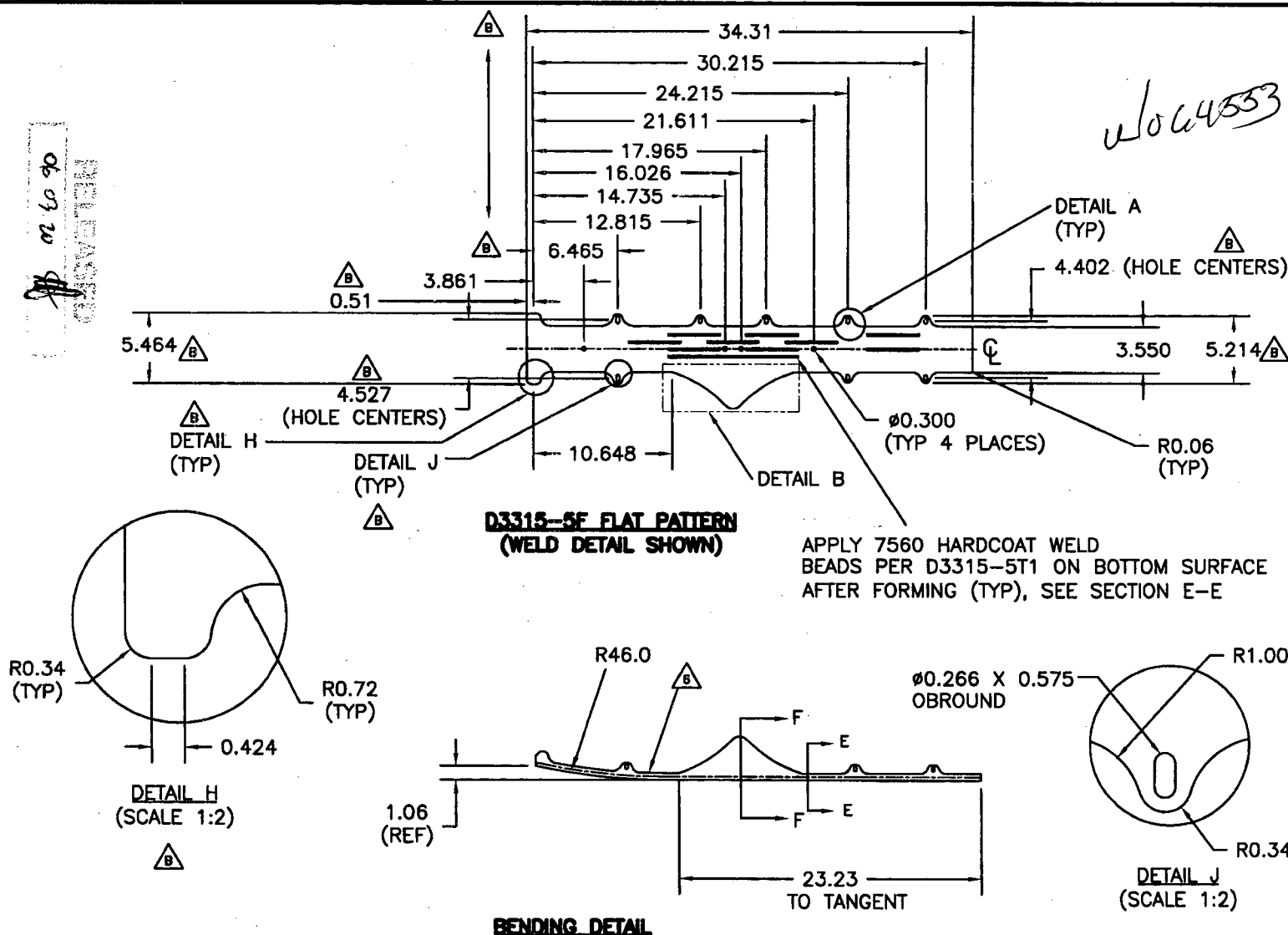
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DH	DRAWN BY	DH	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO.	D3315
DATE	06.01.31	TITLE	WEARPLATE	SHEET 3 OF 4	REV. B
		SCALE	1:12		



D3315-5 WEARPLATE SHOWN (-6 OPPOSITE)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSION ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

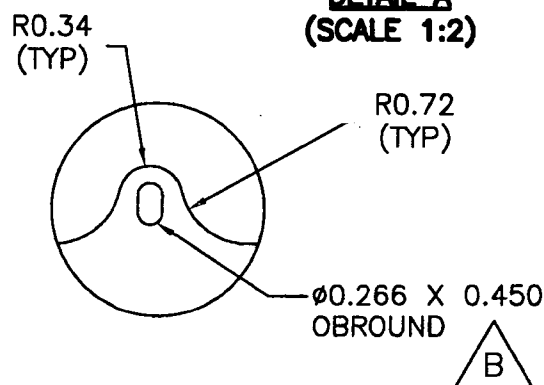
NOTE: Date & initial all entries

DART

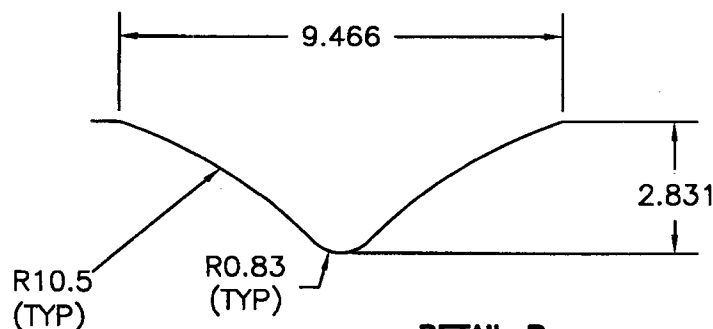
DESIGN	PH	DRAWN BY	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	D3315
DATE	06.01.31			TITLE	WEARPLATE
				REVISION	B
				SHEET	4 OF 4
				SCALE	NTS

u/o 64553

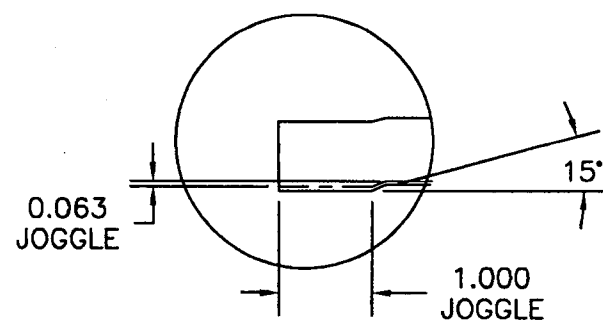
DETAIL A
(SCALE 1:2)



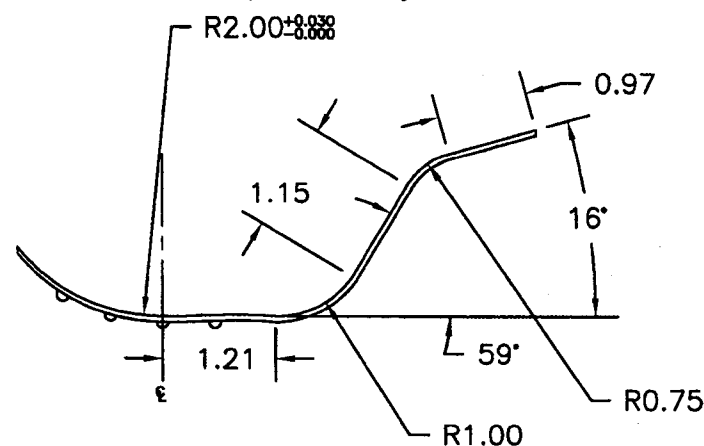
DETAIL B
(SCALE 1:4)



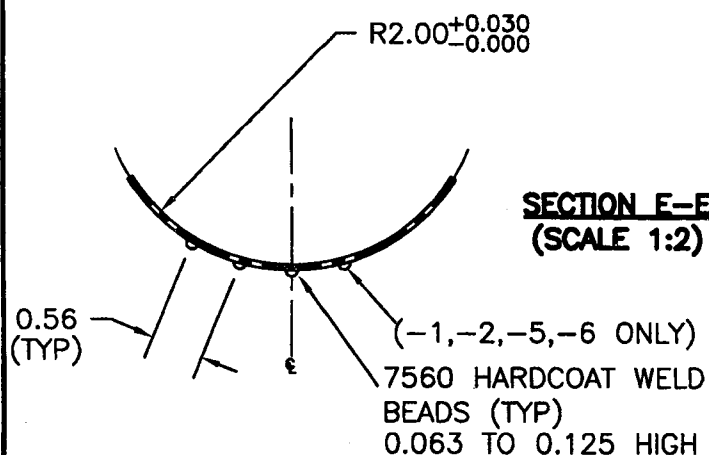
DETAIL D
(SCALE 1:2)



SECTION F-F
(SCALE 1:2)



SECTION E-E
(SCALE 1:2)



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